

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017043**Date Inspected:** 10-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao, Wang Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 14, "K" PLATE SUBASSEMBLY

FCAW welding of weld joint 008 located on KP3008-001.

Welder is identified as 067079. ZPMC QC is identified as Mr. Wang Xu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

BAY 15, 13AW BOTTOM PLATE

SAW welding of weld joint 001 located on SEG3013AC (BP3074A+BP3075A).

Welders are identified as 045270 and 250050. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

BAY 16, LIFT 13

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint 027 & 043 located on LD3033-001.

Welder is identified as 040344. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 059 & 075 located on LD3034-001.

Welder is identified as 045143. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 025 & 041 located on LD3035-001.

Welder is identified as 045280. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

SAW welding of weld joint 003 located on SEG3013AC (BP3072A+BP3073A).

Welder is identified as 045265. ZPMC CWI is identified as Mr. Wang Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

BAY 19, BIKE PATH (B-WR14786)

During random in process inspection this QA inspector observed that ZPMC personnel performing buttering of approximately 5~10mm on the stringer plate of bike path using Flux Cored Arc Welding (FCAW) process. Welder is

identified as 062862. ZPMC CWI is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR-1/ WPS-345-FCAW-3G(3F)-REPAIR-1. The components are identified as OBG components and the weld designation are identified as follows.

BK004A-012, 010, 008, 011

BK006A-002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh
----------------------	---------------

Quality Assurance Inspector

Reviewed By:	Carreon,Albert
---------------------	----------------

QA Reviewer
